Today Ship August 6

Work Order ID 122772

July-24-14 11:05:49 AM

122772

Item ID: D4364-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Plate

Start Date: 7/24/14 **Start Qty:** 2.00 *2*

Required Date: 7/25/14 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4364	B								
100		0.00							DAS 23 9-89 14-07-24
100						2	0		
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4364-1) F-deviated140724Rev b.rd Dwg Rev: F- Deviated Prog Rev: F- Deviated 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89 14-07-24
110						2	0		
QC	**Memo**	0.00							
Quality Control									

PO

DQA: [signature] Date: 14/08/07

QA Closed: [signature] Date: 14-7-28

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: 122772

Part No. DL4364-1

NCR No. 14-4077

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☒
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☒ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐ Doc/Data ☒ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Operator ☐ Offset/Setup ☐ Process ☐ Supplier ☐ Training ☐ Transport ☐ Unapproved ☐	14/7/24	100	2	DXF # for waterjet was modified with slot at fwd end to allow better forming.	DAS 12 9-89 14/7/24	Minor deviation Acceptable. Overall bent shape identical	DAS 12 9-89 14/7/24	SMP 14/7/24	SMP 14/7/24

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 122772

July-24-14 11:05:49 AM

122772

Item ID: D4364-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Plate

Start Date: 7/24/14 **Start Qty:** 2.00 *2*

Required Date: 7/25/14 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00	DAS 27 9-89			2	0	0	DAS 12 9-89 14/07/24
120									
QC	**Memo**	0.00							
Quality Control									
130	Form as per dwg	0.00			DAS 30 9-89	2			14/07/24
130									
Brake NC	**Memo**	0.00							
Brake NC	*** Jigs DT8261 and DT8326.***								
140	QC5- Inspect part completeness to step on W/O	0.00	DAS 27 9-89 14/7/25			2			
140									
QC	**Memo**	0.00							
Quality Control									

Item ID: D4364-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Plate

Start Date: 7/24/14 **Start Qty:** 2.00 *2*
Required Date: 7/25/14 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: WA001	0.00							
200						2	14-07-28		MAL
Packaging	**Memo**	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210							14/7/28		
QC	**Memo**	0.00							
Quality Control									

14-7-28

Picklist Print

July-24-14 11:05:48 AM

Work Order ID: 122772 *122772*

Parent Item: D4364-1 *D4364-1*

Parent Item Name: Plate

Start Date: 7/24/14 **Required Date:** 7/25/14

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A 14.04.22 DWG B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA *M304S18GA* 304/316 .050 Sheet		Purchased	No				sf	636.9700	**	6			DAS 23 9-89 14-07-24

Location		Loc Qty	Loc Code	
MAT019		624.97		
	117188	3		
	117766	5		
	120604	5		
	122325	3		
	123155	3		
	124572	38		
	M126647	31.55		
	M128254	90.17		
	M128435	123.25		
	M128864	64		
	M129530	259		129530
MAT020		12		
	124029	2		
	M126098	10		

DART AEROSPACE LTD	Work Order:	122772.
Description: Plate	Part Number:	D4364. 1 Deviated
Inspection Dwg: D4364 Rev: B - Deviated		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125"	±0.010"	0.125"	–		V	JKm01
1.00"	±0.030"	1.003"	–		V	
0.450"	±0.010"	0.448"	=		V	
0.400"	"	0.401"	✓		V	
5.770"	"	5.764"	–		V	
15.450"	"	15.450"	–		T	JKm07
30.175"	"	30.175"	–		T	
42.175	"	42.175"	–		T	
43.35"	±0.030"	43.35"	–		T	
4.20"	"	4.206"	–		V	
0.75	"	0.758"	–		V	
4.00"	"	4.005"	–		V	
3.00"	"	3.009"	–		V	
0.050"	±0.010"	0.048"	–		V	
0.56"	±0.030"	0.562"	–			

Measured by:	DAS 23 9-89
Date:	14-07-24

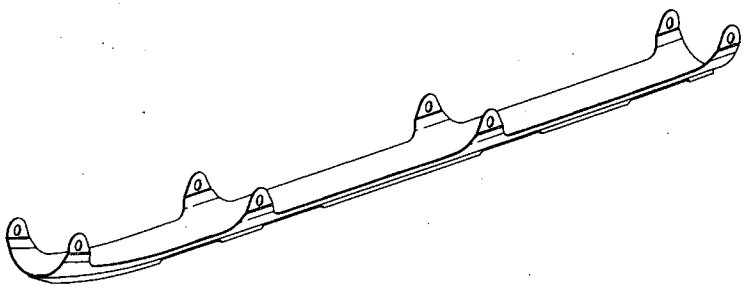
Audited by:	DAS 27 9-89
Date:	14/7/28

Preliminary Approval:	
Date:	

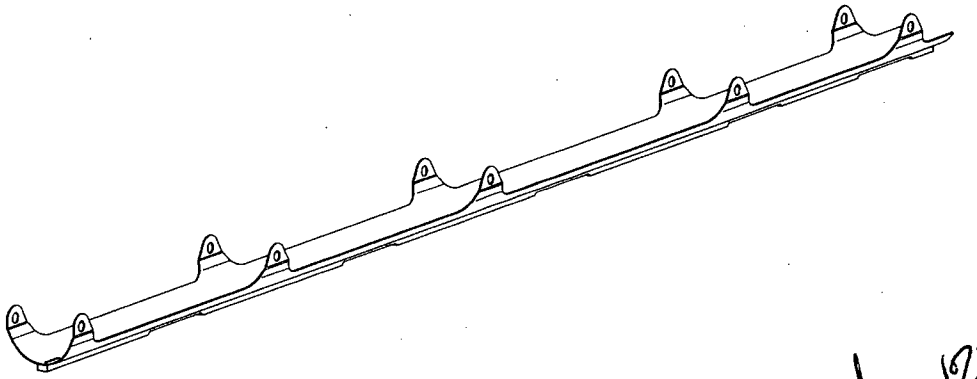
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D4364-041	FWD WEARPLATE ASSY
		X	D4364-043	AFT WEARPLATE ASSY
1	1		D4364-1	PLATE
2		1	D4364-3	PLATE
3	1		D4365-1	BAR
4		1	D4365-3	BAR
5	A/R	A/R	2059B	HARDCOAT
B 6	A/R	A/R	TEXTURED COATING	SEALANT



D4364-041 FWD WEARPLATE ASSY



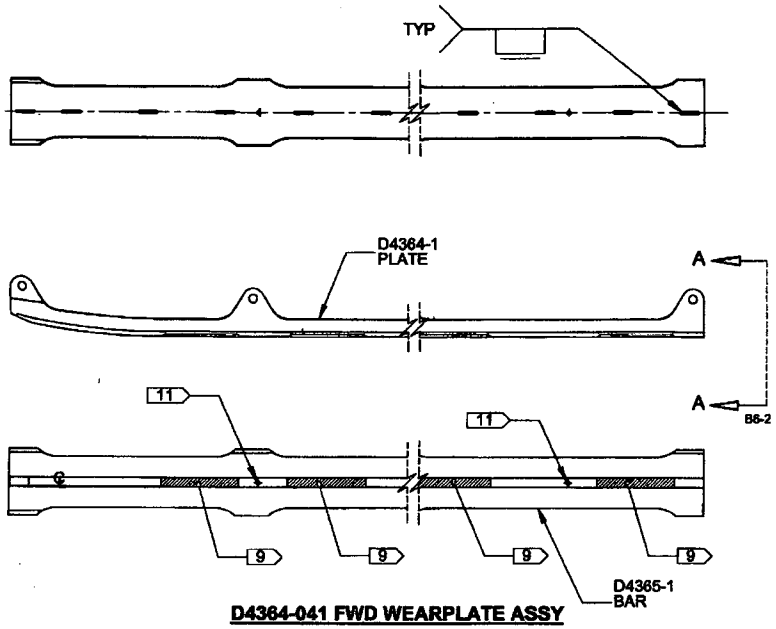
D4364-043 AFT WEARPLATE ASSY

RELEASED
2014 -04- 17

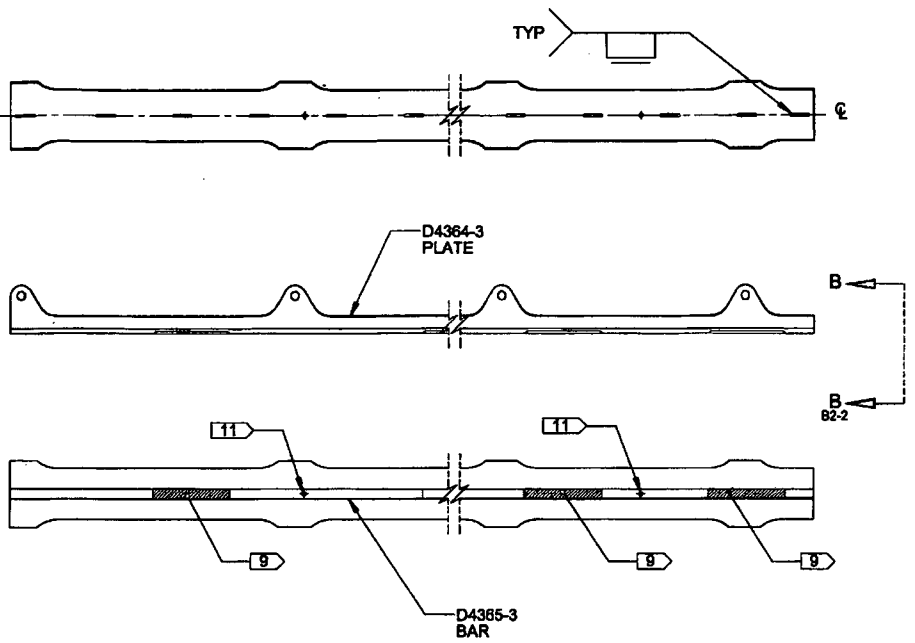
w/o 122772

REV.	DESCRIPTION	BY	DATE
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), CHANGE NOTE 10 (SH 2)	DB	13.11.04
A	NEW ISSUE	SC	11.06.14

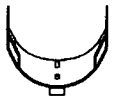
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	DB		
CHECKED		DRAWING NO. D4364	REV. B
MFG. APPR.			SHEET 1 OF 5
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE	13.11.04		



D4364-041 FWD WEARPLATE ASSY



D4364-043 AFT WEARPLATE ASSY



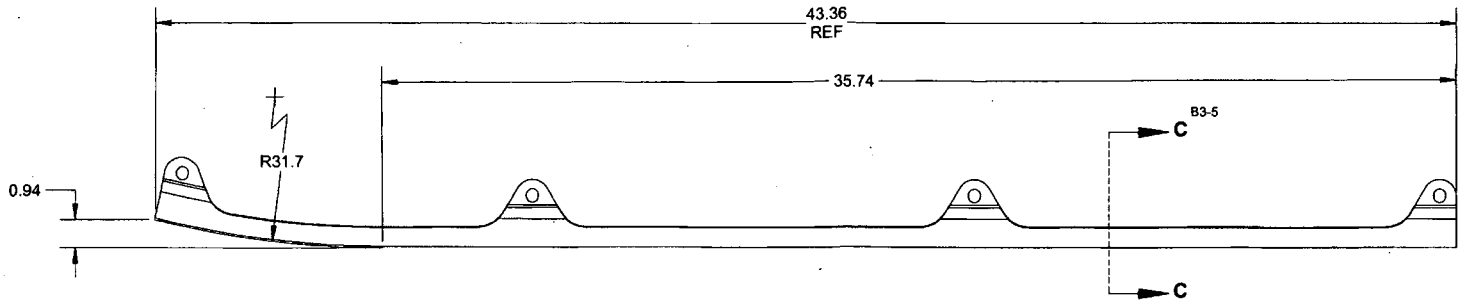
VIEW A-A C5-2

VIEW B-B C1-2

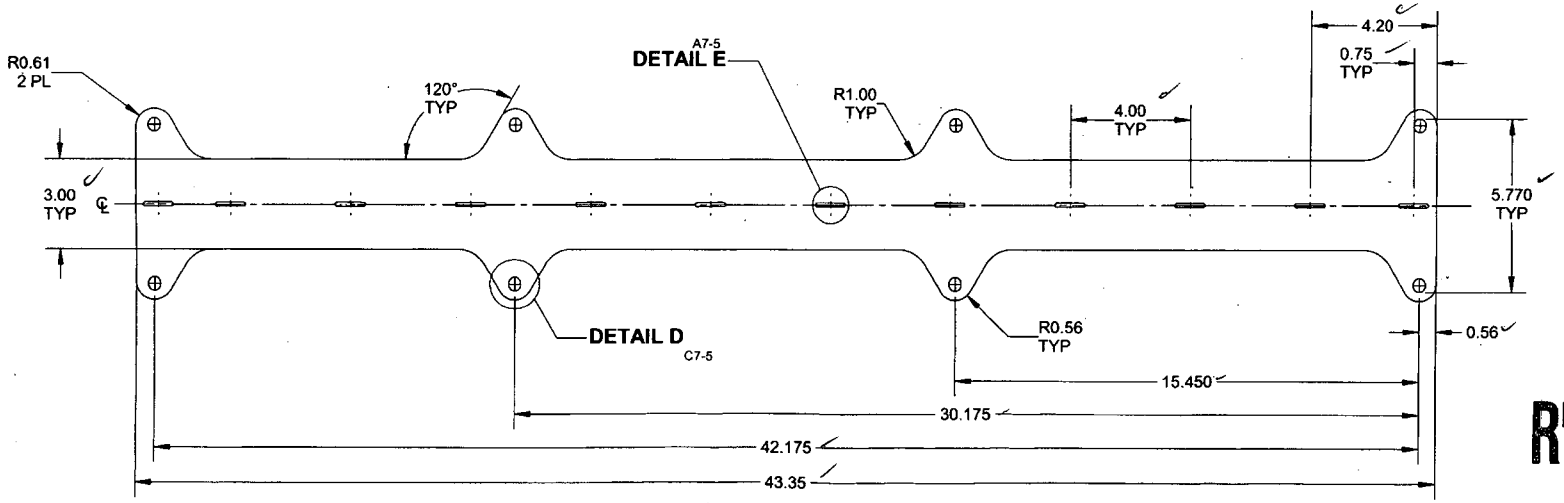
RELEASED
2014 -04- 17

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4364-04X" PER QSI 044 6.1
7) WEIGHT: D4364-041 = 4.03 lbs; D4364-043 = 5.88 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4365-X BAR ON ALL 3 SURFACES
(A) 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
11) TRANSFER DRILL Ø0.188 HOLES FROM D4365-X BAR TO D4364-X WEARPLATE AFTER WELDING

DESIGN	SC	DART AEROSPACE USA, INC.
DRAWN	DB	PORT HADLOCK, WA
CHECKED		DRAWING NO. D4364 REV. B
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	13.11.04	



D4364-1 PLATE
(MAKE FROM D4364-1F)

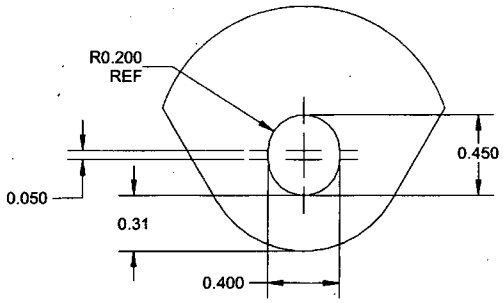


D4364-1F PLATE

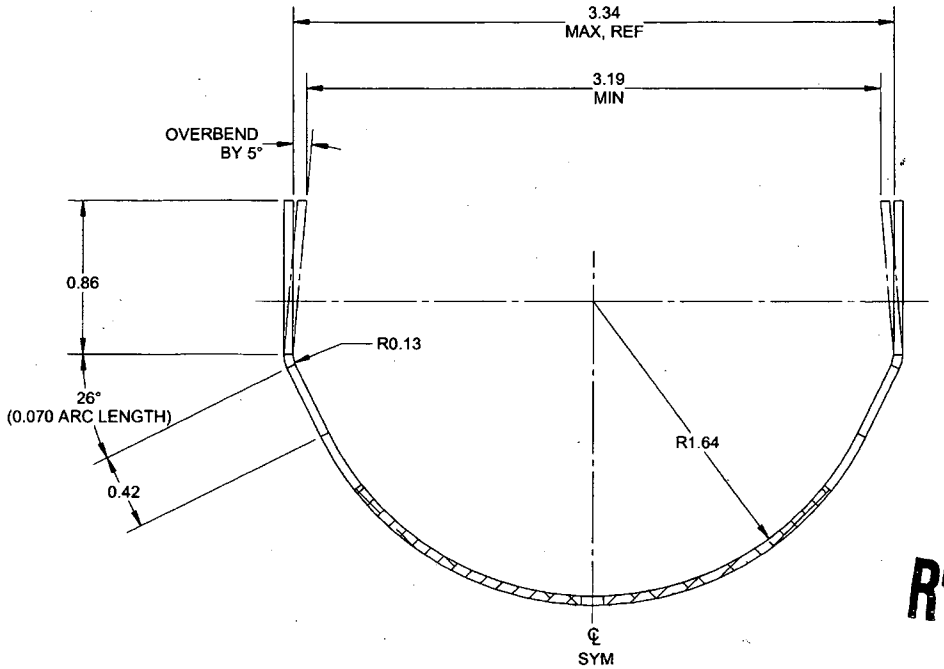
RELEASED
2014 -04- 17

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.12 lbs

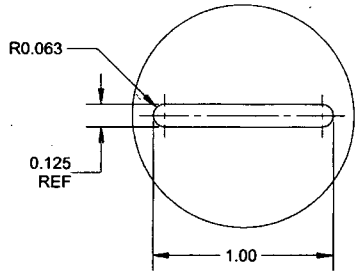
DESIGN	SC	DART AEROSPACE USA, INC.
DRAWN	DB	PORT HADLOCK, WA
CHECKED		DRAWING NO. D4364 REV. B
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE 13.11.04		



DETAIL D
SLOT DETAIL TYP
B5-3
B5-4



SECTION C-C
D3-3
D3-4



DETAIL E
SLOT DETAIL TYP
C5-3
C5-4

RELEASED
2014 -04- 17

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D4364	REV. B
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE 13.11.04			

Linda Lacelle

From: David Duval
Sent: July-24-14 10:57 AM
To: Chris Provencal
Cc: Linda Lacelle; Mike Petsche
Subject: RE: Deviated wearplate flat pattern

It's ready to be cut. Made the change.
It's in approve D4364 and its call D4364-1F-deviated140724 revb.ord

David Duval
Production Engineering Coordinator

From: Chris Provencal
Sent: Thursday, July 24, 2014 10:35 AM
To: David Duval
Cc: Linda Lacelle; Mike Petsche
Subject: Deviated wearplate flat pattern

David,

They're having problems with the production D4364 wearplates. The front end is lifting off the skidtube creating a gap. I've created a deviated flat pattern (attached) based on the Fort Rucker wearplates (206 A/B wearplates) that fit OK. I've basically cut and paste the front end from that wearplate onto this one.

We'd like to treat this as a deviated part so we can sell it. Can we create a waterjet program for the deviated dxf?

We'd like to keep the Rev. letters the same so Linda can create w/o's for the parts and I'll sign off that there's a minor change to the approved flat pattern.

I'm assuming that Linda needs it ASAP.

Thanks,
Chris